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D5369-2
Job Sheet 197760

Part No: D5369-2		Job Qty: 5 pcs
Part Name: Cable Guard		
Part Weight: 0 lbs	Status: New	Priority: Medium
Job Created: 7/16/19	Job Tracking No:	
Due Date: 8/30/19	Created By: Manon Dubois	
Type: Stock	Description:	
Note: DWG REV A IPP REV:A 15.12.09 NEW ISSUE DD VERF:JLM		
Ship Via:		

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	5 pcs	8/30/19	8/30/19	0.00	20.05	Bandsaw - 1		
110	HAAS 4 Axis - B4B	5 pcs	8/30/19	8/30/19	0.76	20.05	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	5 pcs	8/30/19	8/30/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		

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130 QC 8	5 pcs	8/30/19	0.00 0.00	QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	2019/08/22
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	2019/08/23
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
140 Packaging 3-1 - Stock - B4B 5 pcs ✓		8/30/19	0.00 0.00	QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B →	SI 479A
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	

Mon 8-26-2019
Oscar

				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150 QC 21 - SA	5 pcs ✓	8/30/19	0.00 0.00	QC 21 - SA - 21 →	DAS ST 479 A DAS
Mon 8-26-2019 Dsea				QC 21 - SA - 70	70 807 979 IV 77
				QC 21 - SA - 53	9-89 9-89
Part Op 100 - Cut at 82.750"					
Descriptions: 110 - (HAAS CNC Vertical Machine), 1-Mill as per folio FB443 & dwg D5369,					
120 - (QC2- Inspect parts off machine FAI/FAIB)					
130 - (QC8- Inspect parts - second check), ENSURE D5369-1/-2 IS MACHINED TO LENGTH AS PER DWG.					
140 - (Identify as per dwg & Stock Location: _____)					
150 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
MUHMWB1.750X1.000X96.00	UHMW 1.75x1.00x96.00 (Tolerance +/- .010) order 120"	32.6000 ft (6:52 ea)	100-Bandsaw	S/43388	
		(6.90m) - 1			
		br			
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Bandsaw - 1	MUHMWB1.750X1.000X96.00	33	98	0	
	x 120.00 DA				
Part Specifications					
Specifications could not be found.					

Plex 7/16/19 10:16 AM Dart.dart.int4

1 part = 82.750"
+ 0.050" (Blade)

1 part = 82.800" ÷ 12 = 6.9 ft each
X 6 parts

41.4 ft

DART AEROSPACE LTD		Work Order:	197760
Description: Cable Guard		Part Number:	D5369-2
Inspection Dwg: D5369 Rev: A		Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.06	+0.020/-0.000	.070	✓		Vernier	
0.13 x 45°	+/-0.030 x +/-0.5°	.115x45°	✓		Vernier	
1.44	+/-0.030	1.436	✓		Vernier	
0.31	+/-0.030	.304	✓		Vernier	
24°	+/-0.5°	24°	✓		Caliper	
50°	+/-0.5°	50°	✓		Caliper	
0.54	+/-0.030	.536	✓		Vernier	
0.31	+/-0.030	.315	✓		high gage	
0.48	+/-0.030	.485	✓		Vernier	
0.87	+/-0.030	.880	✓		Vernier	
1.75	+/-0.030	1.748	✓		Vernier	
Ø0.316	+0.006/-0.001	.316 Ø	✓		Pin gage	
2.00	+/-0.030	1.994	✓		Vernier	
1.63	+/-0.030	1.628	✓		Vernier	
0.29	+/-0.030	.295	✓		Vernier	
7.65	+/-0.030	7.632	✓		Vernier	
8.03	+/-0.030	8.016	✓		Vernier	
8.78	+/-0.030	8.758	✓		Vernier	
9.26	+/-0.030	9.254	✓		Vernier	
12.03	+/-0.030	12.026	✓		Tape	
12.78	+/-0.030	12.774	✓		Tape	
13.16	+/-0.030	13.150	✓		Tape	
20.71	+/-0.030	20.702	✓		Tape	
25.71	+/-0.030	25.700	✓		Tape	
43.71	+/-0.030	43.700	✓		Tape	
61.71	+/-0.030	61.700	✓		Tape	
65.66	+/-0.030	65.640	✓		Tape	
72.76	+/-0.030	72.750	✓		Tape	
73.00	+/-0.030	72.00	✓		Tape	
76.09	+/-0.030	76.10	✓		Tape	
76.92	+/-0.030	76.930	✓		Tape	
78.12	+/-0.030	78.125	✓		Tape	

Measured by:	<i>M.M.</i>	Checked by:	<i>Onf</i>	QC Inspector:	
Date:	2019/08/19	Date:	19/08/23	Date:	

Engineering Approval:	DAS	Date:	
(If necessary)	64		
	9-89		

Rev	Date	Change	Revised by	Approved
A	16.03.30	New Issue	KJ	<i>[Signature]</i>

Entered: _____ Date: 19-08-20



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____ Route update only ☐

Job: <u>197760</u>		DISPOSITION		DEPARTMENT/PROCESS			
Part No. <u>D5369-2</u>		Rework ☐ Scrap ☒ Use-as-is ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date: <u>19-08-19</u>	Sequence #: <u>110</u>	QTY Affected: <u>1</u>		MRB (QS1042)			
Description Work Order Deviation		Disposition					
<u>Wrong Origine position</u>		<u>Scrap and replace</u>					
Completed By <u>W. H.</u>		Lead hand / Supervisor <u>La 19-08-20</u>					
QC / QA Coordinator							
Root Cause		FAULT CATEGORY					
☒ Operator		☐ Pressure/Forced		☐ Contamination		☒ Positioned Wrong	
☐ Manufacturing Process		☐ Bending		☐ Misaligned/off center		☐ Outside Tolerance	
☐ Equip/Tooling		☐ Crushing		☐ BOM/Route		☐ Drawing	
☐ Handling/Preservation		☐ Cracks		☐ Broken/Damage/Defect		☐ Finish	
☐ Material		☐ Crimp/Kink/Ripple/Wave/Twist		☐ Incomplete/Unclear Instructions		☐ Part Lost/Missing	
☐ Product Improvement		☐ Marks/Chatter		☐ Drill Holes		☐ Misread	
☐ Process Improvement		☐ Mislabeled		☐ Fit/Function		☐ Out of Sequence	
☐ Human Factors		Other/Details: <u>Wrong origine</u>		☐ Wrong Stock Pulled		☐ Off-set/Set-up	